

Work Order ID 82175***82175***

Page 1

Friday, March 23, 2012 1:30:34 PM

Item ID: K10111

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Skidtube 206

Start Date: 3/23/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 3/30/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan: Date: 12-03-23

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

DSI 9583

A

K10111

B

0.00

100

100

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile & type labels per PPP K10111 CHG003
FOR D206-642-111 CHG007
FOR D206-642-113 CHG002*JB*

0.00

110

110

Packaging

Packaging

Pick Kit

Memo

0.00

0.00

5 12-06-13
JD Cor MLT 12-6-12
(5)
5 12/06/12 JB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82175

Friday, March 23, 2012 1:30:34 PM

82175

Page 2

Item ID: K10111

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Saddle, Skidtube 206

Start Date: 3/23/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 3/30/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00				5			12/06/13
120									
QC	Memo	0.00							
Quality Control									
130	Packaging	0.00							12/6/13
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP K10111								
	PPP D206-642-111								
	PPP D206-642-113								
	Location: <u>PK</u>								
	PPP rev: <u>G</u>								
140	QC21- Final Inspection - Work Order Release	0.00							12/6/14
140									
QC	Memo	0.00							
Quality Control									

ME
12-06-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 1

Friday, March 23, 2012 1:30:40 PM

Work Order ID: 82175

82175

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 3/23/2012

Required Date: 3/30/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP: F01.11.08 Revised Step 5 and Added Inspection Level
21SM IPP REV:G
11.09.23 PER REV.B DD VERF:EC IPP REV:H 11.11.14
AS PER DSI9583 DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3-41A Bolt		Purchased	No			110	Each	435.0000	8	40			
									**				

Location Loc Qty Loc Code

ST335 235
120644 235
ST354 200
120498 200

AN4-6A
Bolt

Purchased No 110 Each 1,515.0000 12

**

Location Loc Qty Loc Code

ST356 1515
119017 1515

AN4C5A
BOLT

Purchased No 110 Each 256.0000 1

**

Location Loc Qty Loc Code

ST355 256
112243 156
119017 100

120498

121631 JB

5

119017

JB 12/06/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 2

Friday, March 23, 2012 1:30:40 PM

Work Order ID: 82175

82175

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 3/23/2012

Required Date: 3/30/2012

Start Qty: 5.00

Required Qty: 5.00

AN5-10A
AN5-10A
Bolt

Purchased No

110 Each

358.0000

4

20

**

121181 JB

Location

Loc Qty

Loc Code

ST337

358

118191

80

120630

30

120717

50

120770

198

AN5-11A
AN5-11A
Bolt

Purchased No

110 Each

733.0000

4

20

**

JB

Location

Loc Qty

Loc Code

ST337

733

118191

13

119512

720

AN6-44A
AN6-44A
Bolt

Purchased No

110 Each

105.0000

2

10

**

119212 JB 12/06/12

Location

Loc Qty

Loc Code

ST343

7

119127

7

st510

98

119036

98

119036

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 82175

82175

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 3/23/2012

Required Date: 3/30/2012

Start Qty: 5.00

Required Qty: 5.00

D206-651-041

Manufactured No

110

Each

20.0000

0

5

**

83388 JB



D206-651-041

206A/B GHW

Location

Loc Qty

Loc Code

FG120

10

79558

10

FG125

10

81288

10

D2652

Manufactured No

110

Each

628.0000

16

80

**

83744 JB



D2652

Bushing

Location

Loc Qty

Loc Code

FG

44

31985

44

ST013

584

73834

15

73836

36

76134

1

76136

55

77134

400

77136

77

D2661-1

Manufactured No

110

Each

16.0000

2

10

**

6x 83489 JB 12/06/12
4x 80989



D2661-1

Saddle, LH Fwd Aft Out 206

Location

Loc Qty

Loc Code

MEZZ

7

64559

5

76730

2

ST434

9

80412

9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Friday, March 23, 2012 1:30:40 PM

Page 4

Work Order ID: 82175

82175

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 3/23/2012

Required Date: 3/30/2012

Start Qty: 5.00

Required Qty: 5.00

D2662-1

Manufactured No

110

Each

12.0000

2

10

**

D2662-1

Saddle, LH In 206

Location

Loc Qty

Loc Code

ST435

12

80414

12

110

Each

962.0000

10

50

**

D2712

Manufactured No

D2712

Set Screw

Location

Loc Qty

Loc Code

FG

50

29962

50

ST017

700

79585

500

81871

200

ST021

212

76065

212

110

Each

123.0000

2

10

**

D2884

Manufactured No

D2884

Saddle Spacer

Location

Loc Qty

Loc Code

FG

10

29453

10

ST020

113

76751

113

35x79585
15x81871

76751

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 5

Friday, March 23, 2012 1:30:40 PM

Work Order ID: 82175

82175

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 3/23/2012

Required Date: 3/30/2012

Start Qty: 5.00

Required Qty: 5.00

D2885

Manufactured No

110

Each

114.0000

2

10

**

JB



D2885

Saddle Spacer

Location

Loc Qty

Loc Code

FG

10

29199

10

ST020

104

76752

104

76752

D3413-1

Manufactured No

110

Each

72.0000

0

5

**

83307

JB



D3413-1

Ring

Location

Loc Qty

Loc Code

ST420

17

70773

1

79233

16

ST464

55

76754

33

80224

22

MS2104213

Purchased No

110

Each

2,835.000

8

40

**

121349

12/06/12



MS2104213

Nut

Location

Loc Qty

Loc Code

ST300

2835

117441

16

117885

32

118451

5

118927

3

119017

2613

119075

166

Friday, March 23, 2012 1:30:40 PM

Shop Packet Print

Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

Page 6

Friday, March 23, 2012 1:30:40 PM

Work Order ID: 82175

82175

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 3/23/2012

Required Date: 3/30/2012

Start Qty: 5.00

Required Qty: 5.00

MS21042L4

Purchased

No

110

Each

4,785.000

12

60

MS21042L 4

Nut

**

121444 JB

Location

Loc Qty

Loc Code

ST300

4785

119017

14

119075

2771

121011

2000

MS21042L6

Purchased

No

110

Each

926.0000

2

10

MS21042L 6

Nut

**

JB

Location

Loc Qty

Loc Code

ST300

926

117677

25

118384

3

118927

48

119075

650

120308

200

NAS1149C0463R

Purchased

No

110

Each

1,018.000

1

5

NAS1149C0463R

Washer

**

JB

12/06/12

Location

Loc Qty

Loc Code

FP001

1

115358

1

ST297

1017

117735

46

119097

971

119097

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Page 7

Friday, March 23, 2012 1:30:40 PM

Work Order ID: 82175

82175

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 3/23/2012

Required Date: 3/30/2012

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0363J

Purchased

No

110

Each

1,417.000

8

40

**

121524 JB

NAS1149D0363.I

Washer

Location

Loc Qty

Loc Code

ST298

1417

117601

61

118077

1

118612

18

119537

33

120142

134

120308

162

120644

1000

120986

8

NAS1149D0463J

Purchased

No

110

Each

1,948.000

24

120

**

121912 JB

NAS1149D0463.I

Washer

Location

Loc Qty

Loc Code

ST297

1787

121011

1787

ST298

161

116805

0

118384

16

119097

145

NAS1149D0563J

Purchased

No

110

Each

2,892.000

8

40

**

JB 12/06/12

NAS1149D0563.I

Washer

Location

Loc Qty

Loc Code

ST298

2892

118206

19

118614

456

119546

2000

119717

417

119246

Friday, March 23, 2012 1:30:40 PM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 8

Friday, March 23, 2012 1:30:40 PM

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82175

Parent Item: K10111

K10111

Parent Item Name: Saddle, Skidtube 206

Start Date: 3/23/2012

Required Date: 3/30/2012

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0663J

Purchased

No

110

Each

658.0000

4

20

NAS1149D0663.I

Washer

**

121444 JB

12/06/12

Location

Loc Qty

Loc Code

ST298

658

119075

158

120644

500

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.2 206A/B LOW GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES)

ITEM	QTY -113	QTY -114	QTY -151	QTY -149	PART NUMBER	DESCRIPTION
	X				D206-642-113	SKIDTUBE INSTALLATION, LH
		X			D206-642-114	SKIDTUBE INSTALLATION, RH
	1	1	X		D206-642-151	SKIDTUBE
				X	D206-642-149	RUN-ON LANDING WEARPLATE KIT
	1	1			D206-651-041	* 206 GHW ADAPTER ⁽²⁾
1			1		D3804-041	SKIDTUBE ASSEMBLY
2A			6		D2651-1	* PLUG ⁽¹⁾
2B			6		D2651-3	* O-RING ⁽¹⁾
3			1		D2646	* AFT CAP ⁽¹⁾
4			2		MS27039-1-08	* SCREW ⁽¹⁾
5			2		NAS1149D0332J	* WASHER ⁽¹⁾ (OR AN960JD10L)
6	1				D2661-1	SADDLE, FWD OUT, LH
6		1			D2661-2	SADDLE, FWD OUT, RH
7	1				D2662-1	SADDLE, FWD IN, LH
7		1			D2662-2	SADDLE, FWD IN, RH
8	1				D2661-1	SADDLE, AFT OUT, LH
8		1			D2661-2	SADDLE, AFT OUT, RH
9	1				D2662-1	SADDLE, AFT IN, LH
9		1			D2662-2	SADDLE, AFT IN, RH
10	8	8			AN3-41A	BOLT
11	16	16			D2652	BUSHING
12A	8	8			MS21042-3	NUT (OR MS21042L3)
12B	8	8			NAS1149D0363J	WASHER (OR AN960JD10)
13	4	4			AN5-7A	BOLT
14	4	4			AN5-7A	BOLT
15	8	8			NAS1149D0563J	WASHER (OR AN960JD516)
16	12	12			AN4-6A	BOLT
17	24	24			NAS1149D0463J	WASHER (OR AN960JD416)
18	12	12			MS21042-4	NUT (OR MS21042L4)
20A			1	1	D3805-041	FWD WEARPLATE ASSY
21A			1	1	D3807-1	* GASKET ⁽³⁾
22A			1	1	D3805-045	AFT WEARPLATE ASSY
23A			1	1	D3807-5	* GASKET ⁽⁴⁾
26A			7	7	AN3-36A	BOLT
26B			7	7	NAS1149D0363J	WASHER (OR AN960JD10)
26C			7	7	MS21042-3	NUT (OR MS21042L3)
26D			14	14	D3873-1	BUSHING
27				2	D2649	SPACER
28	2	2			AN6-44A	BOLT
29A	2	2			MS21042-6	NUT (OR MS21042L6)
29B	4	4			NAS1149D0663J	WASHER (OR AN960JD616)
34	1	1			AN4C5A	BOLT
35	1	1			NAS1149C0463R	WASHER (OR AN960C416)
36	1	1			D3413-1	RING
37	10	10			D2712	SET SCREW
38	2	2			D2884	SPACER
39	2	2			D2885	SPACER

- NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3804-041 ASSEMBLY ABOVE
 (2) NOT INSTALLED AS PART OF SKIDTUBE. USED TO MODIFY OEM GROUND HANDLING WHEELS
 (3) DENOTES THAT PART IS INCLUDED WITH D3805-041 ASSEMBLY ABOVE
 (4) DENOTES THAT PART IS INCLUDED WITH D3805-045 ASSEMBLY ABOVE

REFERENCE ONLY

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D206-642 REV. O AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D206-642 REV. 4

REF FAA STC: SA00475SE

REF CANADIAN STC: SH98-4

REF EASA STC: EASA.IM.R.S.01320

PROCEDURE:

FOR D206-642-113/-114 SKIDTUBE INSTALLATION KITS, IT HAS BEEN DETERMINED THAT AN5-10A (FWD) AND AN5-11A (AFT) BOLTS ARE MORE APPROPRIATE BOLT LENGTHS FOR ATTACHING THE SKIDTUBES TO THE CROSSTUBES THAN THE AN5-7A BOLTS PREVIOUSLY PROVIDED IN THE KITS.

4.2 206A/B LOW GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES)

32.12 206A/B LOW GEAR SKIDTUBES (WITH RUN-ON LANDING WEARPLATES)

ITEM	QTY. -113	QTY. -114	PART NUMBER	DESCRIPTION
			D206-642-113	SKIDTUBE INSTALLATION, LH
			D206-642-114	SKIDTUBE INSTALLATION, RH

IS:

13	4	4	AN5-10A	BOLT
14	4	4	AN5-11A	BOLT

WAS:

13	4	4	AN5-7A	BOLT
14	4	4	AN5-7A	BOLT

FOR FURTHER DETAILS REFER TO PAGE 22, DETAIL A OF IIN-D206-642 REV. O, OR PAGE 30, DETAIL A OF ICA-D206-642 REV. 4.

A	NEW ISSUE	AJS	11.11.02
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE USA, INC KENT, WA	
DRAWN	AJS		
CHECKED	q	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9583	SHEET 1 OF 1
APPROVED	10	TITLE	SCALE
DE APPR.	H	BOLT SUBSTITUTION	NTS
DATE	11.11.02	<small>COPYRIGHT © 2011 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	